

Date: Wednesday, 3/7/2007 8:38:04 AM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FITTING
Job Number : 31031	
Estimate Number : 10844	
P.O. Number : <u>N/A</u>	Part Number : D2249041
This Issue : 3/7/2007 S.O. No. : <u>N/A</u>	Drawing Number : D2249 REV. E
Prsht Rev. : NC	Project Number : N/A
First Issue : <u>N/A</u> Type : SMALL /MED FAB	Drawing Revision : E
Previous Run : <u>N/A</u>	Material : <u>N/A</u>
Written By : <u> </u>	Due Date : 4/10/2007
Checked & Approved By : <u> </u>	Qty: <u>5</u> Um: <u>10</u> Each
Comment : Est: D05.02.04 Added Step 9 KJ/RF	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	31031A	LUG
-----	--------	-----



Comment: Sub-Component LUG

D2249-1 B 31031A

FC 07/03/22

(10)

2.0	31031B	LUG
-----	--------	-----



Comment: Sub-Component LUG

D2249-3 B 31031B

FC 07/03/22

(5)

3.0	31031C	GUSSET
-----	--------	--------



Comment: Sub-Component GUSSET

D2249-5 B 22498

FC 07/03/22

(10)

4.0	D22491	Lug
-----	--------	-----



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Lug

Pick:

Qty Part Number Description Batch

1 D2249-1 Lug B31031A

FC 07/03/22

(10)

5.0	D22493	Base Plate
-----	--------	------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 10.0000 Each(s)

Base Plate

Pick:

Qty Part Number Description Batch

1 D2249-3 Base Plate B31031B

FC 07/03/22

(6)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/29

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 3/7/2007 8:38:04 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FITTING

Job Number: 31031

Part Number: D2249041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D22495

Gusset



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Gusset

(2) D2249-5 blanks per (1) D2249-041

Pick:

Qty	Part Number	Description	Batch
2	D2249-5	Gussett	"B22498"

Batch

"B22498"

FC 07/03/22

(10)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld as per Dwg D2249 and QSI 004

FC 07/03/22

(5)

8.0

QC59

WELD INSPECTION



Comment: WELD INSPECTION

FC 07/03/23

(5)

9.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.2) as per QSI 005 4.3

M103706

M-L

07/03/26

(5X)

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

FC 7/3/28

(5)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

FC 7/3/28

(5)

12.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

FC 07/03/29

(5)

Job Completion



U 07-03-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

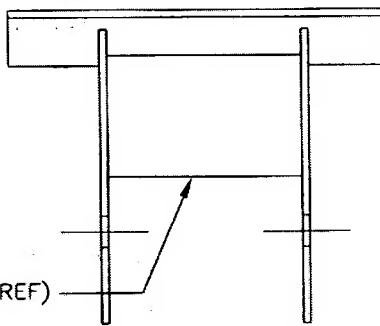
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

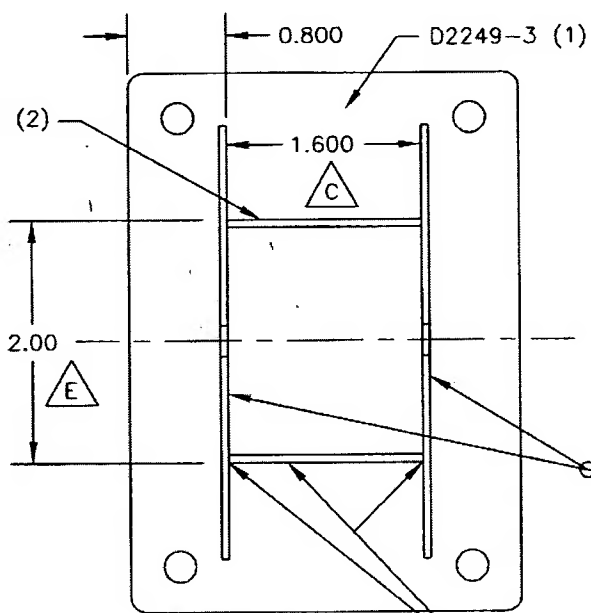


RELEASED
99.10.12 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
AE	RF		
CHECKED KE	APPROVED [Signature]	DRAWING NO. D2249	SHEET 1 OF 4
DATE 99.09.20		TITLE FITTING	SCALE NFS
A	99.06.20	NEW ISSUE	
B	95.11.30	DIMENSION CHANGE	
C	95.12.14	DIMENSION CHANGE	
D	98.04.30	90.261 WAS 98.257 (TSR A179) REMOVED DUPLICATE DIMENSIONS	
E	99.09.20	ADDED GUSSET	

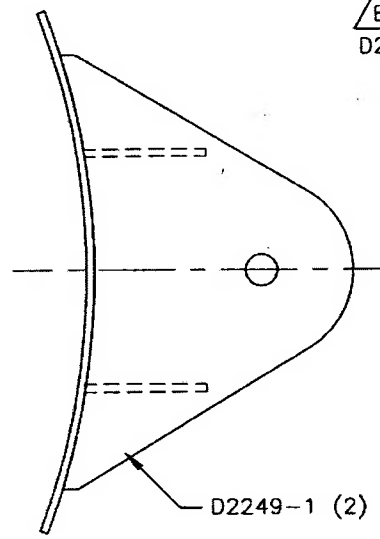


E D2249-5 (REF)



WELD
USING TOOL
DT8209

TYP
E



D2249-1 (2)

D2249-041 ASSEMBLY

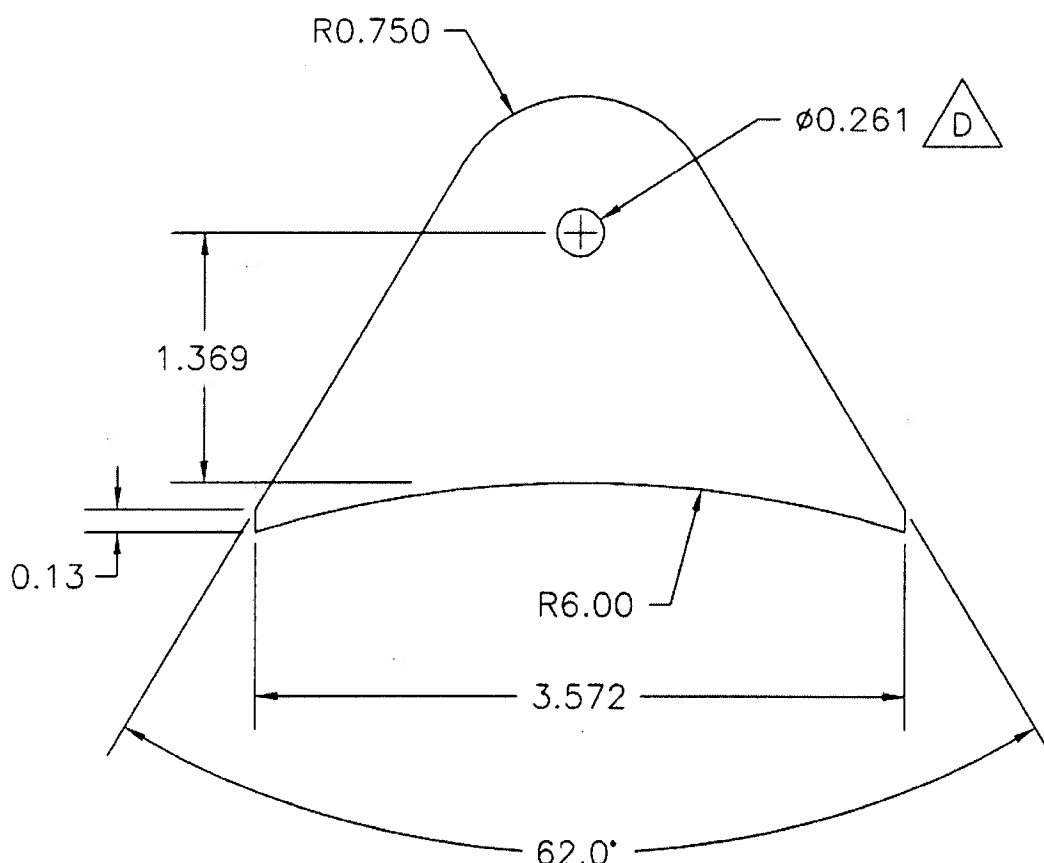
MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

SHOP COPY
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WITHOUT NOTICE



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 2 OF 4
DATE 99.09.20	TITLE FITTING		SCALE 1:1

RELEASED
99.10.12 KE



D2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK

ALL DIMENSIONS ARE IN INCHES

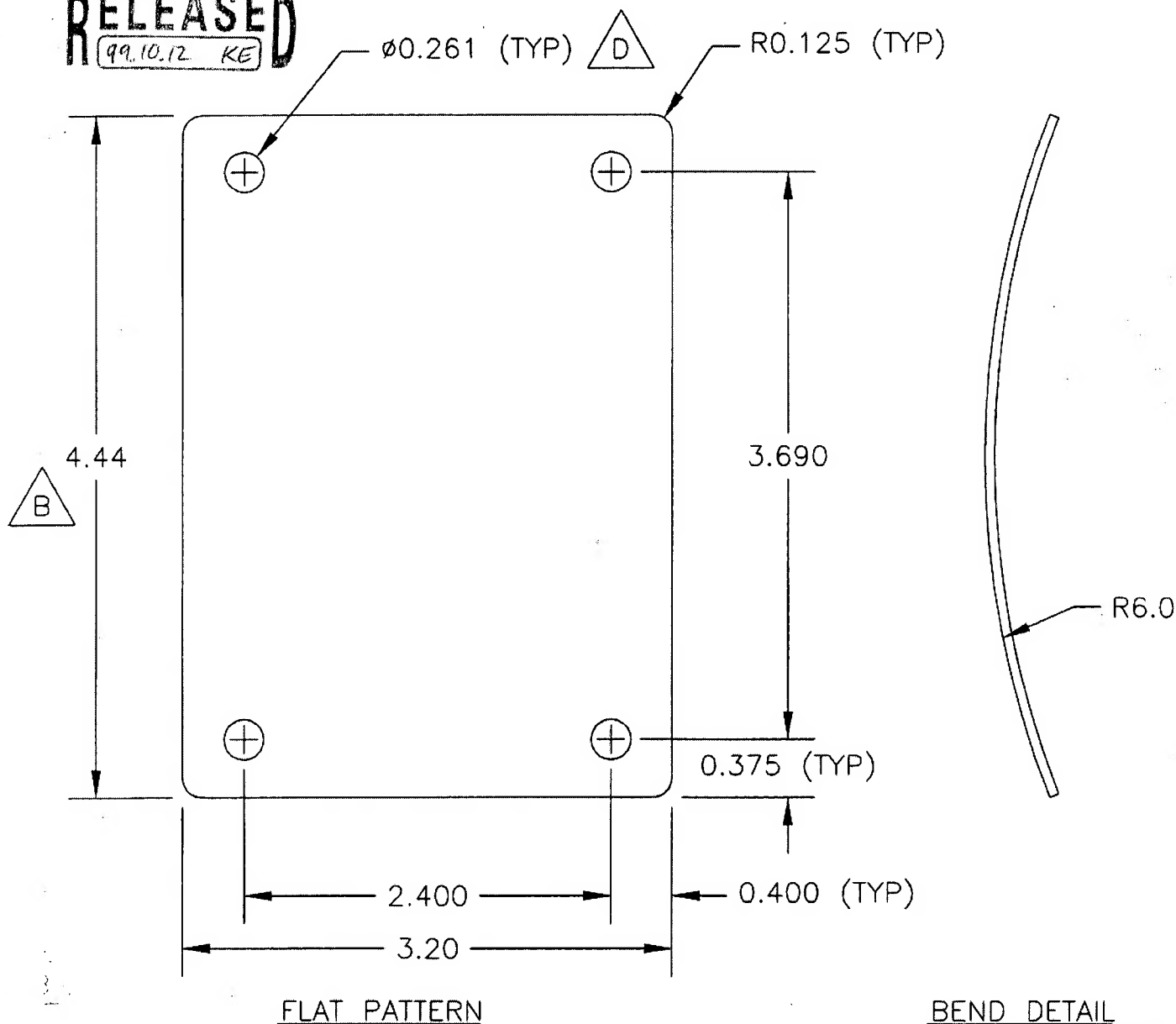
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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WORK ORDER
NO. 31031



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CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 3 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
99.10.12 KE



FLAT PATTERN

BEND DETAIL

D2249-3 BASE PLATE

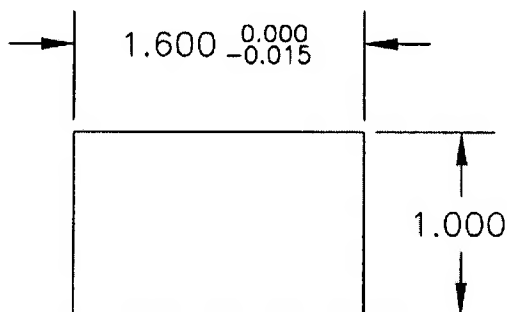
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NO. 31031

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED



DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED
49.10.12 KE



D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK
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TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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